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D2562-001 Job Sheet 189601



Part No: D2562-001

Job Qty: 8 pcs

Part Name: Strut 19.68"



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/28/19

Job Tracking No:

Due Date: 2/15/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG REV D IPP F 02.04.15 Added dwg Rev.B1 NG

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Small Fab - Brake NC <i>20.73</i>	8 pcs	2/15/19		0.00	2.12	Small Fab - Brake - 1			<i>58</i>
							Small Fab - Brake - 2			<i>9-89</i>
							Small Fab - Brake - 3			
110	Small Fab - 2 - B4B	8 pcs	2/15/19		0.00	1.92	Small Fab - 1 - B4B			<i>58</i>
							Small Fab - 2 - B4B			<i>9-89</i>
							Small Fab - 3 - B4B			
							Small Fab - 4 - B4B			
							Small Fab - 5 - B4B			
							Small Fab - 6 - B4B			
							Small Fab - 7 - B4B			
120	QC 5	8 pcs	2/15/19		0.00	0.00	QC 5 - 10			
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			<i>DAS</i>
							QC 5 - 38			<i>38</i>
							QC 5 - 42			<i>9-89</i>
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			
							QC 5 - 9			
							QC 5 - 50			
							QC 5 - 30			
130	Powdercoat - 2 White GI(S)-B4B	8 pcs	2/15/19		0.00	0.33	Powdercoat - 1 - B4B			
							Powdercoat - 2 - B4B			

				Powdercoat - 3 - B4B	BK 19-02-4
				Powdercoat - 4 - B4B	
140 QC 3	8 pcs	2/15/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 38	EB
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	
				QC 3 - 9	
150 Packaging 3-1 - Stock - B4B	8 pcs	2/15/19	0.00 0.00	Packaging 3 - 1 - B4B	QF 333 FEB 04 2018
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	

				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
160 QC 21 - SA	8	2/15/19	0.00 0.00	QC 21 - SA - 21	DAS 21
	pcs			QC 21 - SA - 70	9-88 FEB 06 2019

Part Op **100** - Punch ends and deburr as per dwg)Punch to length as per Dwg D2562
 Descriptions: **110** - Small Fab)1- Bend end as per Dwg D2562 Angle "D"

120 - (QC5- Inspect part completeness to step on W/O)

130 - (White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) START TIME: 1:40 CV. Ti 400° FINISH 2:10

140 - QC3- Inspect Part Finish)

150 - (Identify as per dwg & Stock Location:_____)

160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TR0.500W.035	304 Round Tube .500 X .035W	13.6536 ft (1.7067 ea)	100-Small Fab - Brake NC	<u>SI48224</u>

Job Allocations

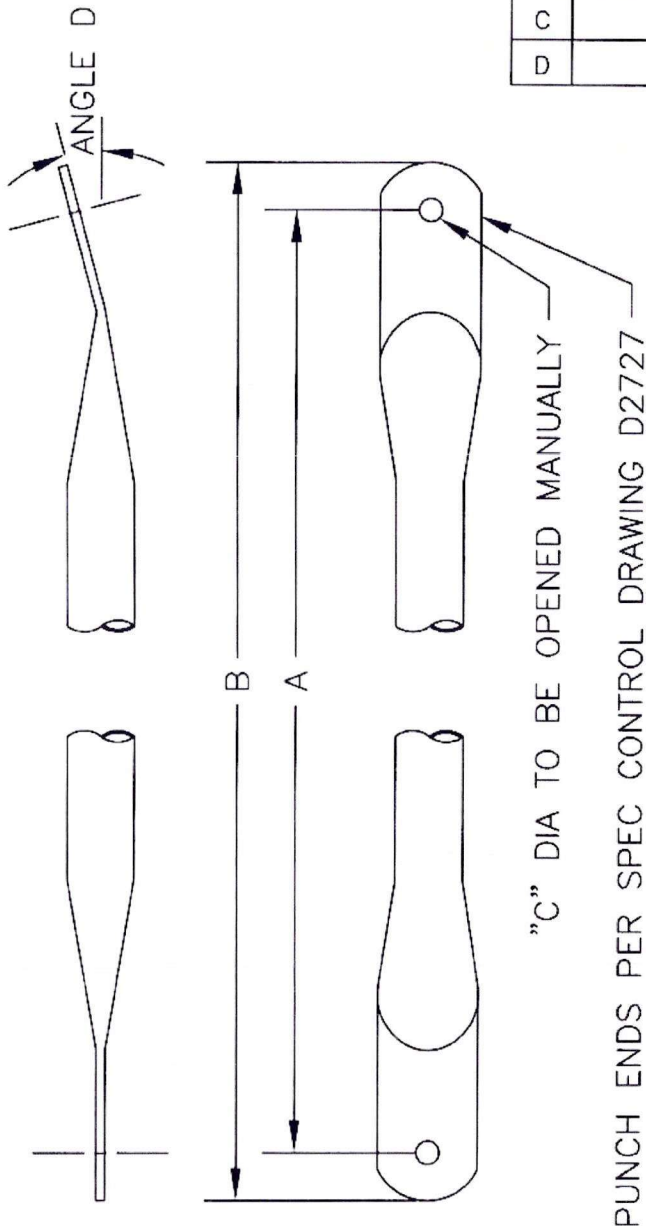
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - Brake NC	M304TR0.500W.035	14	33	0

Part Specifications

Specifications could not be found.



DESIGN CP	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2562	REV. D SHEET 1 OF 1
DATE 05.05.18		TITLE STRUT	SCALE 1:2
A	96.05.01	NEW ISSUE	
B	98.10.15	UPDATED MATERIAL NOTE (TSR A603)	
C	02.06.05	ADD -005; ADD FINISH	
D	05.05.18	ADD -007/-011/-013; UPDATE -005	



PART #	DIM A	DIM B	DIA C	ANG D
D2562-001	19.68	20.48	-	10
D2562-003	20.37	21.17	-	18
D2562-005	29.00	29.80	-	30
D2562-007	19.22	20.02	-	0
D2562-011	25.79	26.59	-	16
D2562-013	26.63	27.43	-	24

- GENERAL NOTES
- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TRO.500W.035) ENSURE SEAMLESS TUBE IS USED
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
05-05-27

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S150416



Part: D2562-001

Job No: 189601

Serial No/Batch: S150416

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/04/19